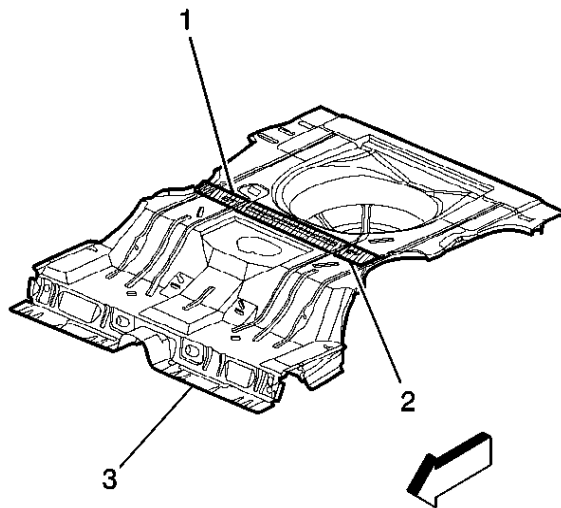


Floor Panel Replacement

Removal Procedure

Caution: Refer to [Approved Equipment for Collision Repair Caution](#) in Cautions and Notices.



Important: The damaged rear floor is cut along the rearward edge of the rear crossbar (1), and the service part is cut to that the new floor section extends to the forward edge of the rear crossbar (2). This allows the two sections to overlap where the crossbar is attached (2). The service part is supplied as a rear floor assembly (3) which requires cutting to fit. The cut will be about 845 mm (33¼ in) from the rear edge of the forward panel.

1. Disable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) in SIR.
2. Disconnect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) in Engine Electrical.
3. Remove all related panels and components.
4. Repair as much of the damage as possible to factory specifications. Refer to [Dimensions - Body](#) .

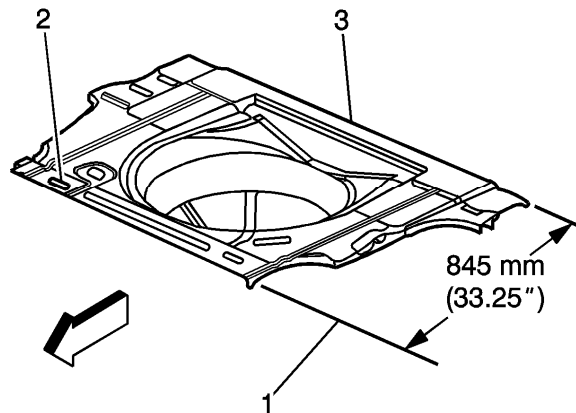
Caution: Refer to [Foam Sound Deadeners Caution](#) in Cautions and Notices.

5. Note the location and remove the sealers and anti-corrosion materials from the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint/Coatings.
6. Remove the quarter panel. Refer to [Quarter Panel Replacement](#) .
7. Remove the rear end panel. Refer to [Panel Replacement - Rear End](#) .
8. Locate and mark all factory welds rearward of the rear crossbar including those along the lower edge of the wheelhouse.
9. Note the number and location of welds for installation of the floor service assembly.

Important: Drill out the factory welds rearward of the crossbar only. Do not drill out the welds attaching the floor to the crossbar.

10. Drill out all factory welds.
11. Cut the damaged floor along the rear edge of the crossbar.
12. Do not damage the following components:
 - The rear rails
 - The crossbar
 - The wheelhouse
13. Remove the damaged floor section.

[Installation Procedure](#)



1. Measure 845 mm (33¼ in) from the rear edge of the rear floor service assembly forward and mark the location (1).
2. Prepare the mating surfaces as necessary.
3. Check for proper fit.
4. Allow the floor service assembly (3) to overlap the original floor on top of the rear crossbar (2).
5. Mark the location of the rear rail and crossbar flanges on the bottom of the floor service assembly.
6. Drill 8 mm (5/16 in) plug weld holes as necessary in the locations noted from the original floor assembly.
7. Drill holes approximately 40 mm (1 in) apart where the new floor section attaches to the rear rail and crossbar flanges.
8. Position the service assembly and check for proper fit.
9. Apply GM-approved Weld-Thru Coating or equivalent to all mating surfaces. Refer to [Anti-Corrosion Treatment and Repair](#) .
10. Plug weld accordingly.
11. Install the quarter panel. Refer to [Quarter Panel Replacement](#) .
12. Install the rear end panel. Refer to [Panel Replacement - Rear End](#) .
13. Clean and prepare all welded surfaces.
14. Apply the sealers and anti-corrosion materials to the repair area, as necessary. Refer to [Anti-Corrosion Treatment and Repair](#) in Paint/Coatings.
15. Paint the repair area. Refer to [Basecoat/Clearcoat Paint Systems](#) in Paint/Coatings.
16. Install all related panels and components.
17. Connect the negative battery cable. Refer to [Battery Negative Cable Disconnect/Connect Procedure](#) in Engine Electrical.
18. Enable the SIR system. Refer to [SIR Disabling and Enabling Zones](#) in SIR.